

Work Order ID 69006

Wednesday, April 27, 2011 8:59:53 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4396-3	Accept		Setup Start	
Revision ID: PRELIM			Stop	
Item Name: Face Plate				
Start Date: 4/27/2011	Start Qty: 10.00		Cust Item ID:	
Required Date: 4/28/2011	Req'd Qty: 10.00		Customer:	
Reference:				



Approvals:	Process Plan: <u>PA1</u>	Date: <u>11-04-27</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4396	PA1								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4396								
2024 0240	Dwg Rev: <u>PM</u>								
	Prog Rev: <u>PA1</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B11-4-27

(10)

B11-4-27

- inspect to PA1

Dwg only

Sublot 27

(410)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4396-3

Accept

Revision ID: PRELIM

Item Name: Face Plate

Start Date: 4/27/2011 Start Qty: 10.00

Required Date: 4/28/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

P BR 11-4-27.

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/4/27 SL 100

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Sent to EAGLE

11/4/27 SL 100

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Item ID: D4396-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Face Plate

Start Date: 4/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
11-04-27

POSITIVE RECALL

EFFECTIVE 4/27/11 AUTH W

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 8:59:59 AM

Page 1

Work Order ID: 69006



Parent Item: D4396-3



Parent Item Name: Face Plate

Start Date: 4/27/2011

Required Date: 4/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.04.27 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	91.5000	0.0873	0.918947			
2024-T3 .040 sheet													



811-4-27

Location

Loc Qty

Loc Code

MAT022

91.5

112291

0.5

112331

27

113162

64

112331

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 69006
Description: FACE PLATE	Part Number: D4396-3
Inspection Dwg: D4396-3, Rev: DAK	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

X

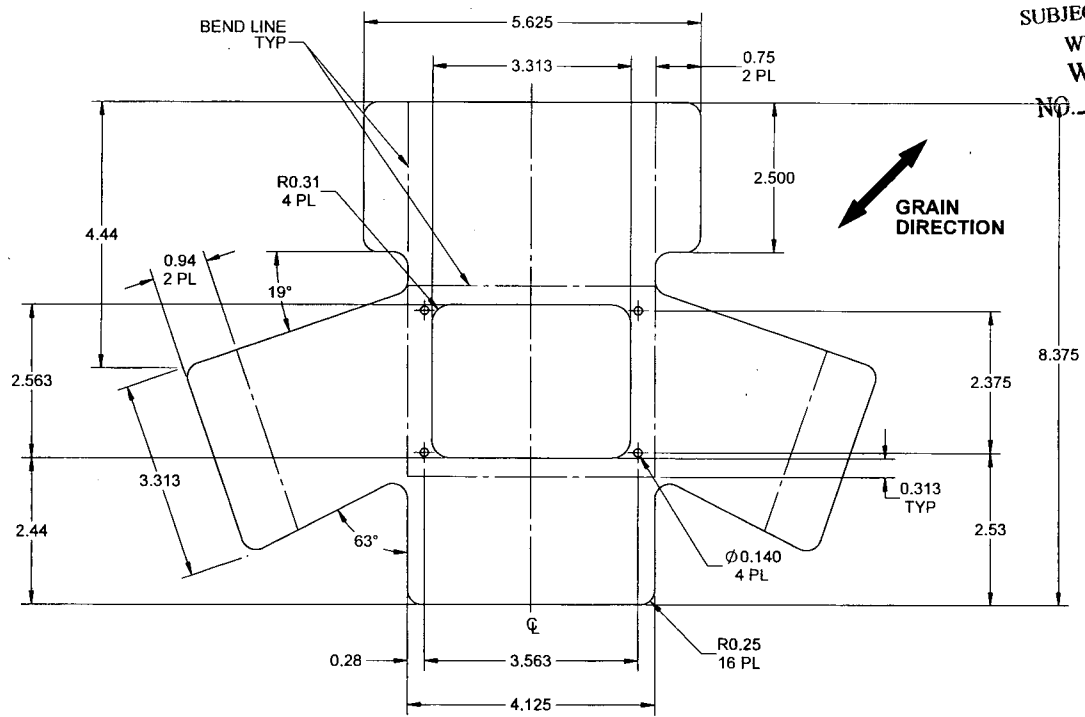
[illegible]

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>11-4-27</u>	Date: <u>11/04/27</u>	Date:

to PSI Day only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 69006 *11-04-27*



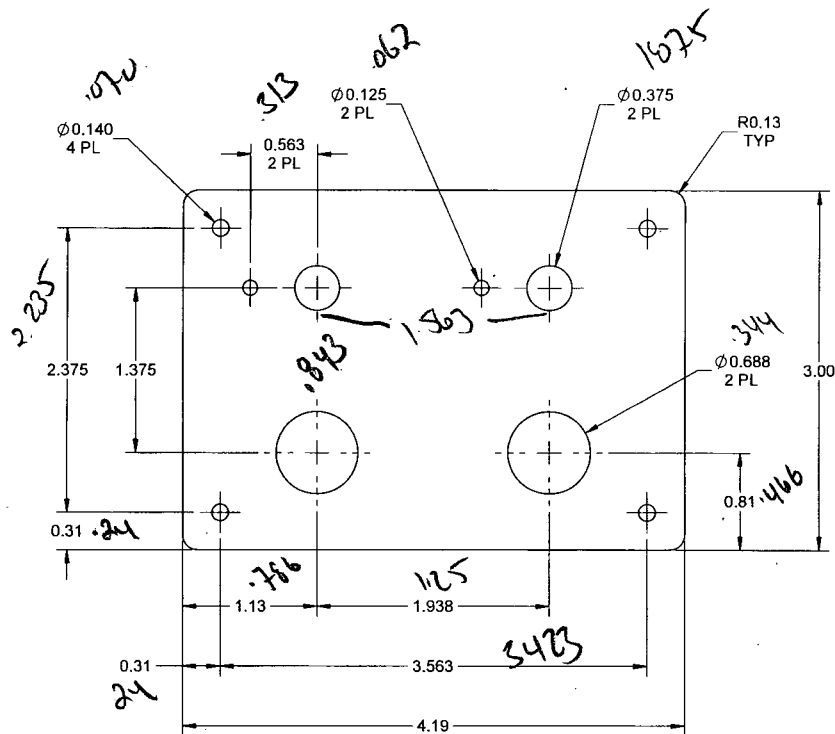
D4396-1F MOUNT FLAT PATTERN

**PRELIMINARY
 ISSUE**

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
 PER QQ-A-250/4 OR AMS-QQ-A-250/4
 OR AMS 4037
 OR ASTM B209
 REF DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

PA1	NEW ISSUE	REV.	DESCRIPTION	RF	11.04.26
DESIGN	RF				
DRAWN	RF				
CHECKED	<i>[Signature]</i>				
MFG. APPR.					
APPROVED	N/A				
DE APPR.	N/A				
DATE	11.04.26				
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w/o 60006

D4396-3 FACE PLATE

**PRELIMINARY
ISSUE**

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REF DART SPEC M2024T3S.040
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4396	REV. PA1
MFG. APPR.		SHEET 2 OF 2	
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	MOUNT	NTS
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